

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002047**Date Inspected:** 27-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Up, OBG Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

(Bay 3), Z. P. M. C., QC, personnel, Magnetic Particle Tested (MT), the root pass of piece number MA29, at MP599-1. The piece was turned over, and Z. P. M. C. personnel, started grinding out a Visual Test (VT), indication, but stopped, prior to completion.

77-meter Mock-Up, Z. P. M. C., Welders, Xu Wei--066253, Fu Yance--066268, welded weld number MUA-MA1-E/F-1 and MUA-MA1-E/F-15, Skin A to Diaphragm. Weld number, MUA-MA1-E/F-4, was welded by Jiang Xiachu--066155. The QA Inspector checked the welding amperage and recorded 246 amps.

Z. P. M. C. personnel, pre-heated, weld number MUSB-MA25, on a Splice Plate, using WPS-B-T-3212-Tc-U5b. When checked by QA, 194 amps was recorded.

(Bay 3), Z. P. M. C., Welder Wang Zhonghua--053753 welded on Plate number 37A, and Bottom Plate (BP)006-01-(008-019), work is in progress.

Summary of Conversations:

No substantial conversations took place.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
